

Work Order ID 148528

Tuesday, July 05, 2016 11:20:01 AM

148528

Page 1

Item ID: D206-642-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Low & High Gear with Standard Wearplates

Start Date: 7/5/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/8/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: TOUCH UP/RETURN TO STOCK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D206-642	Q
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SH SEP 15 2016

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-312 CHG008

DAS
27
9-89

SEP 15 2016

101

0.00

101

SprayPaint

Memo

0.00

Spray Painting

PULL FROM TEST FIT:
1 X D206-642-312 B144570

TOUCH UP TUBE AND SADDLES A/R

DAS
41
9-89

16-7-13

103

QC14- Inspect Spray Paint

0.00

103

QC

Memo

Quality Control

DART aerospace		1270 ABLERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7 TEL: 1-613-632-5200 www.dartaero.com	
PATENT	US #5735484 / CA #2222184 / EURO #0828655		
P/N	D206-642-312	CHG	CHG008
DESC.	Skidtube, RH	STC	SH98-4
LOT	B144570	STC	SA00475SE
MODEL	Bell 206L/L1/L3/L4/407	STC	
TC APPROVAL # 09-89		MADE IN CANADA	
		D2729-4	

2B
16-07-13

Work Order ID 148528

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Item ID: D206-642-312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH, Low & High Gear with Standard Wearplates
Start Date: 7/5/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/8/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: TOUCH UP/RETURN TO STOCK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	ADD TO KIT, MISSING PARTS, SEE ATTACHED PICK SHEET								
	ENSURE ORIGINAL KIT IS ADDED TO BOX								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	REPACKAGE USING NEW B/N NEW LABELS REQUIRED								
	Identify and pack for shipping as per PPP D206-642-312 Location : FG083								

SEP 14 2016

DAS
27
9-89

28
9-89

SEP 15 2016

DAS
27
9-89

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9-89

SEP 15 2016

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Item ID: D206-642-312**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube RH, Low & High Gear with Standard Wearplates**Start Date:** 7/5/2016 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 7/8/2016 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:** TOUCH UP/RETURN TO STOCK**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	QC21- Final Inspection - Work Order Release	0.00							
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140

QC

Memo

0.02

Quality Control

DAS
21
9-89

SEP 15 2016



SEP 14 2016

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148528

D206-642-312

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A *AN3-41A* Bolt		Purchased	No				Each	266.0000		8		PE	28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				20					
				122416				20					
				over003				156					
				123355				156					
				ST347				90					
				123355				90		8			
AN4-6A *AN4-6A* BOLT		Purchased	No				Each	545.0000		12		1/2 M 135 396 PK	28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				over003				400					
				M134943				200		11			
				M135056				200					
				ST345				145					
				M134852				145					

Picklist Print

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Work Order ID: 148528

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Parent Item: D206-642-312

D206-642-312

Parent Item Name: Skidtube RH, Low & High Gear with Standard Wearplates

Start Date: 7/5/2016

Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No

Each 317.0000

D2652

Bushing

**

16

03148315 PC 28 9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	45	
31985	45	
ST009	272	
147559	272	

D2934 Manufactured No

Each 58.0000

D2934

Saddle Spacer

**

2

PC 28 9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	6	
31929	6	
ST014	52	
141428	12	
147488	40	

D2935 Manufactured No

Each 69.0000

D2935

Saddle Spacer

**

2

PC 28 9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	6	
31793	6	
ST014	63	
146008	33	
147574	30	

MS21042-3 MS21042L3 Purchased No

Each 0.0000

MS21042-3

Nut / use MS21042L3

**

8

km B5600 PC 28 9-89

DAS
27
9-89

Tuesday, July 05, 2016 11:20:01 AM

Shop Packet Print

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Picklist Print

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Work Order ID: 148528

148528

Parent Item: D206-642-312

D206-642-312

Parent Item Name: Skidtube RH, Low & High Gear with Standard Wearplates

Start Date: 7/5/2016

Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042-4 MS21042L4 Purchased No

Each 2.0000

MS21042-4

Nut / use MS21042L4

**

12 m135470 pc 28 9-89

Location

Loc Qty

Loc Code

ST304

2

9063

2

Each

1,776.000

**

8 m135297 pc 28 9-89

NAS1149D0363J

Purchased

No

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

418

m134055

418

ST263

1358

m134676

358

m134955

1000

Each

3,463.000

**

24 m135467 pc 28 9-89

NAS1149D0463J

Purchased

No

NAS1149D0463.J

WASHER

Location

Loc Qty

Loc Code

GA

86

M132035

21

M134508

65

ST260a

3000

M134852

1000

M134943

1000

M135056

1000

ST263

377

M127693

24

M134754

353

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Shop Packet Print

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4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12

DQA:

Date:

09/19/2016

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

SEP 19 2016

Work Order update only

Work Order: <u>148528</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>DZ06-642-312</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒		
NCR No. <u>16-6038</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>JULY 12 2016</u>		Step #: <u>101</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
PART WAS USED FOR TRIAL FITTING PURPOSE AND WAS DAMAGED (FINISH) QTY (1)				ACCEPTABLE TO STRIP AND RE-POWDER COAT. strip saddle → <u>DAS 41 9-89 16-7-13</u> Powdercoat white 320 → <u>330 16-07-B</u>				DAS 29 9-89 <u>JULY 13 2016</u>	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☒ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☒ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Mismatched/off center ☐ Turning Sequence ☐					
OTHER: ☐									

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q
 Date: 13.08.12